



Dart Aerospace Ltd.
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D3121-141
Job Sheet 186030



LOAD

Part No: D3121-141

Job Qty: 12 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/18

Job Tracking No:

Due Date: 12/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by: EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	12/3/18	12/3/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	12 pcs	12/3/18	12/3/18	0.00	1.36	Bandsaw1		
110	CNC Vertical Machining	12 pcs	12/3/18	12/3/18	0.47	23.53	HAAS1-3		
120	QC	12 pcs	12/3/18	12/3/18	0.00	0.00	QC2 Machining-1		
130	QC	12 pcs	12/3/18	12/3/18	0.00	0.00	QC8 Machining-1		
140	Small Fab	12 pcs	12/3/18	12/3/18	0.00	0.34	Small Fab-2		
150	QC	12 pcs	12/3/18	12/3/18	0.00	0.00	QC5		
160	Packaging	12 pcs	12/3/18	12/3/18	0.00	0.00	Packaging3-1		
170	QC21-SA	12 Ea	12/3/18	12/3/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks: (1.250" x 2.000") 6.600" long
Descriptions: 110 - 1-Machine D3121-111 as per Folio FA361 and Dwg D3121Identify as D3121-111 3-Scribe batch number
140 - Assemble D3121-141 as per Dwg D3121.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	6.6000 ft (.55 ea)	90-Start up Operation	5120 118
D3121-21	Bolt	12 Ea (1 ea)	140-Small Fab	5132955
D3121-241	Bearing Assembly	12 Ea (1 ea)	140-Small Fab	5133874

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.250X2.000	7	14	0
140-Small Fab	D3121-21	12	5	0
	D3121-241	12	19	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

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Container No: S135087



Part: D3121-141

Job No: 186030

Serial No/Batch: S135087

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/05/10

DART AEROSPACE LTD		Work Order: 186030
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	.393	✓		Micronote	
0.75	+/-0.030	.745	✓		Vernier	
0.375	+/-0.010	.374	✓			
2.14	+/-0.030	2.132	✓		Vernier	
1.96	+/-0.030	1.960	✓		Vernier	
0.280	+/-0.010	.280	✓		Vernier	
3.330	+/-0.010	3.320	✓		Vernier	
3.630	+/-0.010	3.626	✓		Vernier	
R0.25	+/-0.030	R0.250	✓		Gaborit	
R0.375	+/-0.010	R0.375	✓		Gaborit	
Ø0.201	+/-0.010	.195	✓			
0.100	+/-0.010	.098	✓		Vernier	
4.580	+/-0.010	4.575	✓		high gage	
6.18	+/-0.030	6.170	✓		Vernier	
5.89	+/-0.030	5.896	✓		Vernier	
0.080	+/-0.010	.083	✓		Vernier	
0.300	+/-0.010	.302	✓		Vernier	
30°	+/-0.1°	30°	✓		Gaborit	
R0.25	+/-0.030	R0.250	✓		Gaborit	
0.130	+/-0.010	.128	✓		Vernier	
0.664	+/-0.010	.655	✓		high gage	
0.381	+/-0.010	.381	✓		Vernier	
0.201	+/-0.010	.199	✓		Vernier	
0.400	+/-0.010	.394	✓		Vernier	
0.580	+/-0.010	.575	✓		Vernier	
100°	+/-0.1°	100°	✓			
0.032	+0.000/-0.010	-.026	✓		micronote	

Measured by: M.M.	Audited by: [Signature]	Preliminary Approval:
Date: 2018/12/04	Date: 18/12/11	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	
F	13.10.22	Tolerance revised for Ø0.201 dimension	KJ	

